

Date: Tuesday, 03/06/2008 1:03:33 PM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SPRING
Job Number :	39670		
Estimate Number :	10497		
P.O. Number :		Part Number :	D2535
This Issue :	03/06/2008	Drawing Number :	D2535 REV. A
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	1/1	Drawing Revision :	A
Previous Run :	37071	Material :	
Written By :		Due Date :	10/06/2008
Checked & Approved By :	JUD 08.6.03		
Comment :	Est. A99.04.19 New Issue (From hand written IPP) DM		

Qty: 100 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 6491

C 08/06/04

Possible Supplier: Victoria Spring, 0.070 SS Torsion Spring

(100)

2.0	D2535P	Spring
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 100.0000 Each(s)
 SPRING

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

P 8/6/12 (100)

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

Check dims to dwg

S 08/06/12 (100) counted

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 35

P 8/6/13 (100)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPRING

Job Number: 39670

Part Number: D2535

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/06/16 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Cu 08-06-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

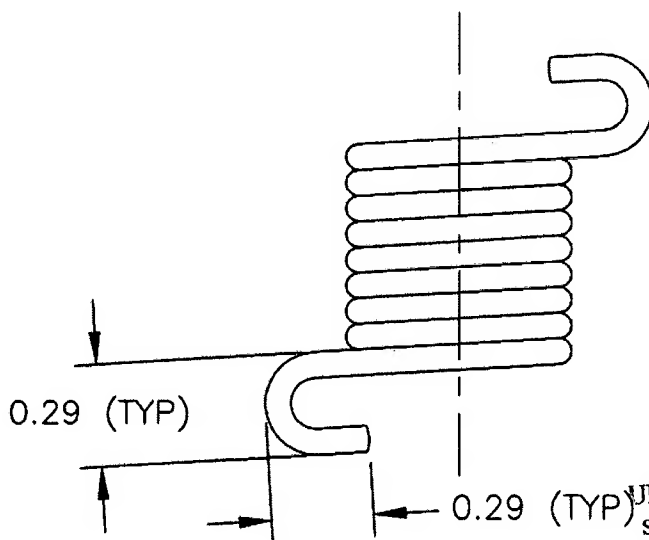
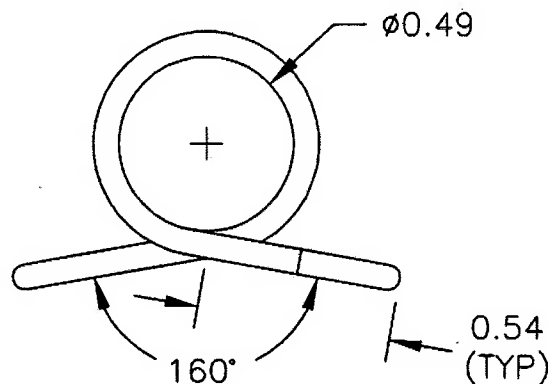
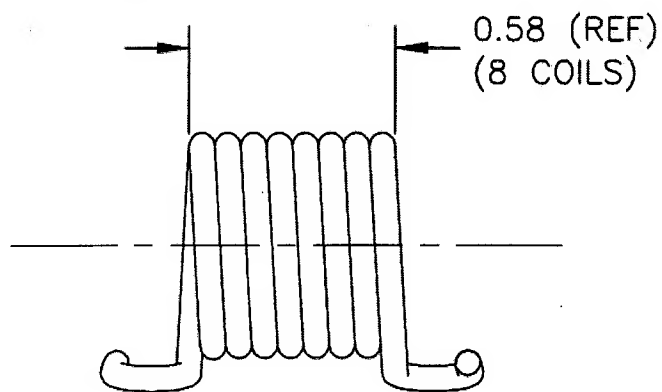
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED JH	DRAWING NO. D2535	REV. A SHEET 1 OF 1
DATE 99.04.08		TITLE SPRING SPEC CONTROL	SCALE 2:1
A	99.04.08	NEW ISSUE	

RELEASED
99.05.11 KE



SHOP COPY
RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31610

SPECIFICATION CONTROL DRAWING

TENSION SPRING WITH 8 COILS (NO GAP BETWEEN COILS)

MATERIAL: AISI STAINLESS STEEL $\phi 0.070$

POSSIBLE SUPPLIERS: VICTORIA SPRINGS, P/N .070SS TENSION SPRING

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

REPORT FOR: Dart Aerospace Ltd.		DATE: 6/11/2008
PO # 6491	PART/DRAWING #: D2535P	
SPRING DESCRIPTION: SS Torsion Spring		QUANTITY: 100

CHARACTERISTIC	SPECIFIED	MEASURED	NOTES
Material type	SS T302	Yes	
Material diameter	.070"	.072"	
I.D.	.490"	.485" / .493"	Min / Max
O.D.			
Number of Coils	8 Ref	Yes	
Free Length			
Helix	RHW	Yes	
End type	As per drawing	Yes	
Rate (lb/in)			
Finish			

COMMENTS

Mill Certificate attached: No
Material Heat Number: N/A

Certified by:

Jeremy Burrows